

NOT IN SYSTEM

Page 1

## Work Order ID 55892

February 4, 2010 8:22:51 AM

Item ID: D4000-11

Accept

Setup Start

Revision ID:

Stop

Item Name: Cap

Start Date: 2/04/10 Start Qty: 2.00

Cust Item ID:

Required Date: 2/11/10 Req'd Qty: 2.00

Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date: 10-2-04

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D4000

A-PRELIM

Rev-A

0.00

100



Waterjet

FLOW CNC Waterjet

6061-30

Memo

1-Cut as per Dwg

Dwg Rev: 025

Prog Rev: 2000

2-Deburr if necessary

0.00

10-2-17

0.00

110



QC

Quality Control

Memo

QC2

0.00

10-2-17

Deburr = 7 m.h 10/02/17

(6X)

(6)

PRELIMINARY ISSUE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 55892

February 4, 2010 8:22:51 AM



Page 2

Item ID: D4000-11

Accept



Setup Start



Revision ID:

Stop



Item Name: Cap

Start Date: 2/04/10

Start Qty: 2.00



Cust Item ID:

Required Date: 2/11/10

Req'd Qty: 2.00

Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120



QC

Quality Control

QC8

Memo

0.00

0.00

8/10/02/17 to PA1

(X6)

no change from PA1 to Rev A Dwg  
not inspected to Released Dwg. 5/10/02/17

170



Packaging

Packaging

Identify as per dwg & Stock Location:

0.00

0.00

Memo

10.04.22 (6) - 1 on W/ 56762

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

Memo

10/09/08

10 test

POSITIVE RECALL

EFFECTIVE 10/20/04

RELEASED

AUTH

DATE

10/08/30

10-2-19 (6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

February 4, 2010 8:22:55 AM

Page 1

Work Order ID: 55892



Parent Item: D4000-11



Parent Item Name: Cap

Start Date: 2/04/10

Required Date: 2/11/10

Comments: IPP rev A 10.02.03 new issue Prelim EC verified by:DD

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.032		Purchased	No			100	sf	128.6824	0.0020	1		
6061-T6 Sheet 0.032"												

B 10-2-17

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	128.6824	
110063	0.009	
112763	80	
16954	3.28225	
18375	45.39115	

6

18375

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

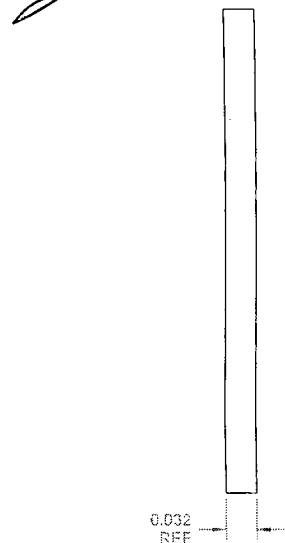


No Acc't

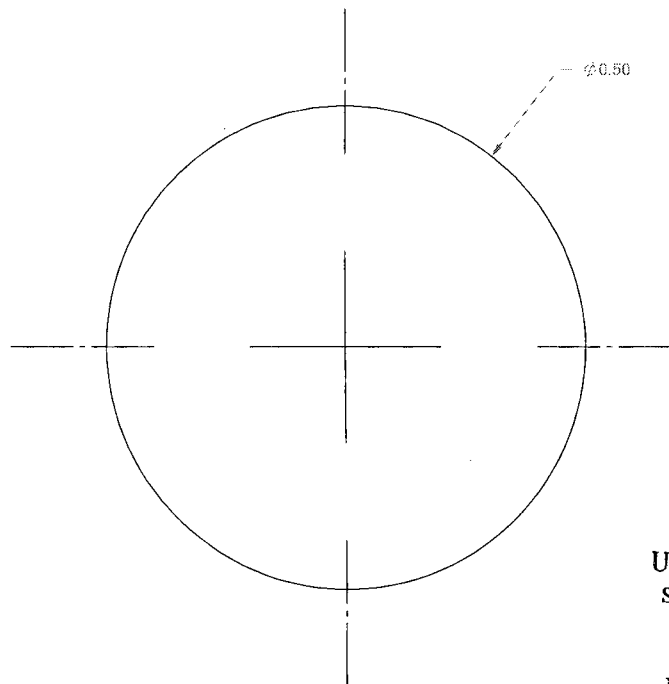
X

x 2

Done



0.032  
REF



0.50

D4000-11 CAP

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 55892

BA 10-204

**PRELIMINARY ISSUE**

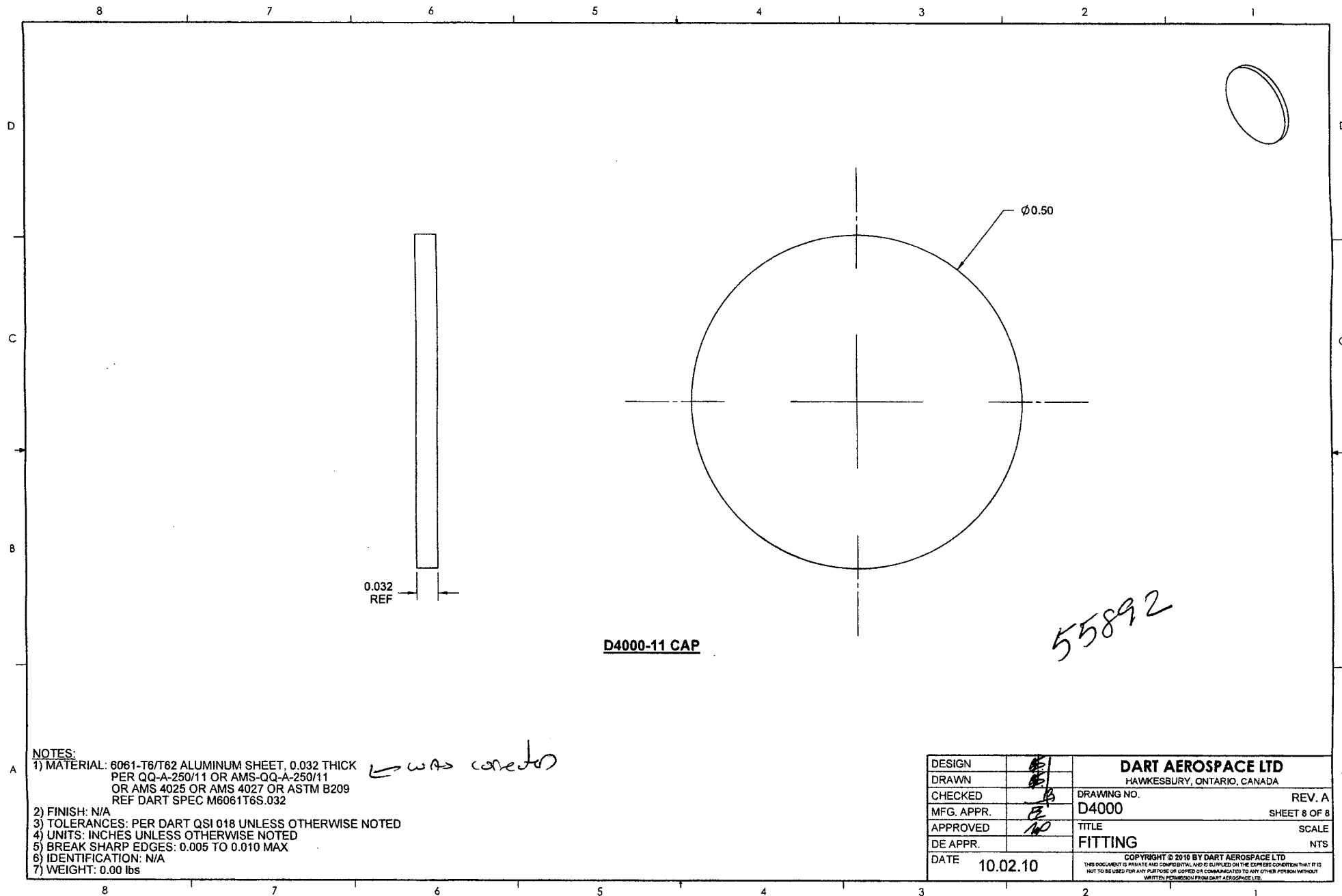
~~09.10.14~~

**NOTES:**

- 1) MATERIAL: PERFORATED ALUMINUM, 0.032 THICK ← wrong  
REF DART SPEC MPAA/80324X10B SCREEN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.00 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	DRAWING NO.	REV: PA1	
MFG. APPR.	D4000	SHEET 8 OF 8	
APPROVED	TITLE	SCALE	
DE APPR.	FITTING	NTS	
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**NOTES:**

1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.032 THICK  
PER QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027 OR ASTM B209  
REF DART SPEC M6061T6S.032

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

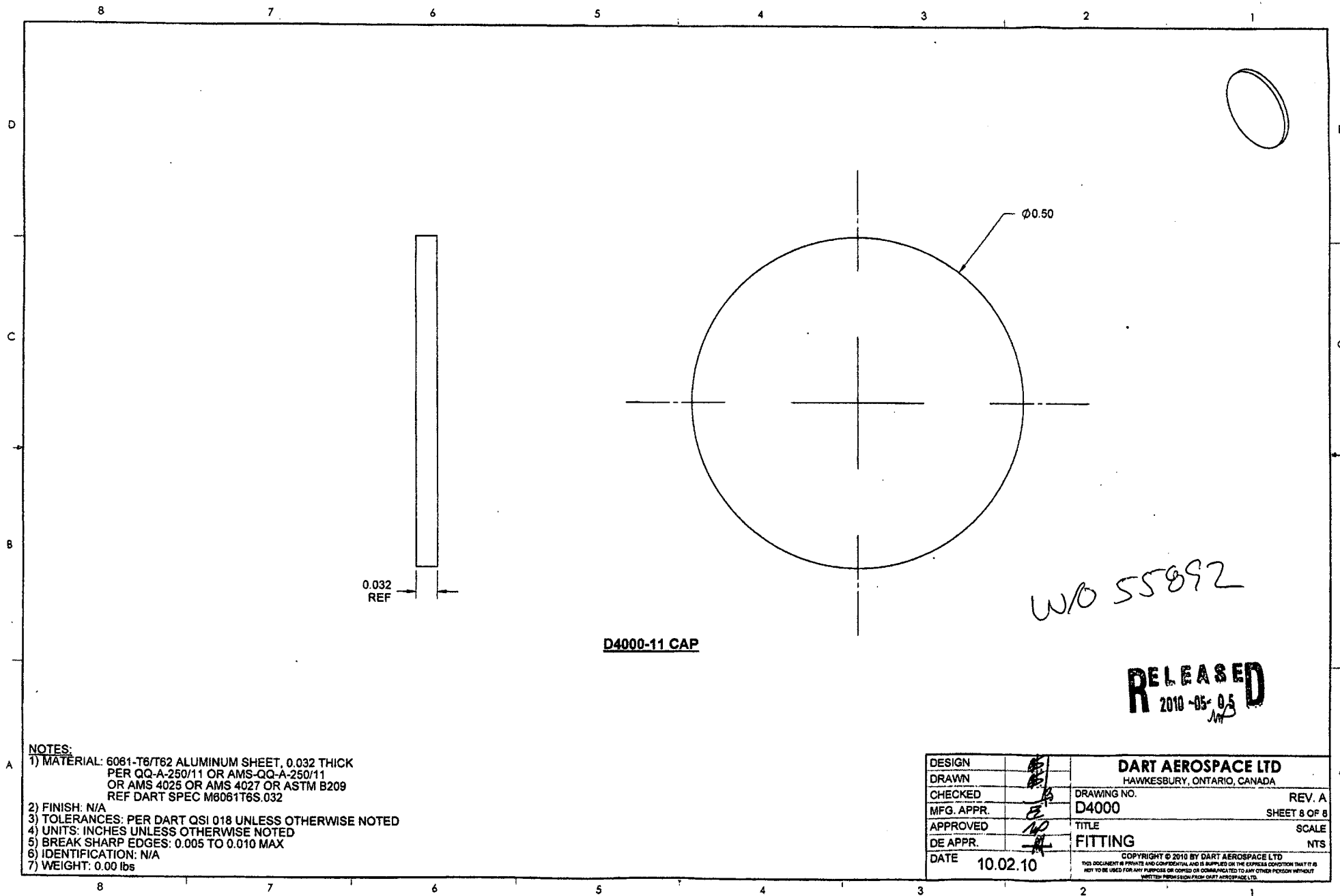
4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: 0.00 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4000	SHEET 8 OF 8
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**D4000-11 CAP**

W/O 55892

**RELEASED**  
2010-05-05

**NOTES:**

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.032 THICK  
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REF DART SPEC M6061T6S.032
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MFG. APPR.		D4000	SHEET 8 OF 8
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